

Date: Thursday, 01/05/2008 10:03:54 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SUPPORT ASSEMBLY
Job Number	: 38929		
Estimate Number	: 10464		
P.O. Number	:	Part Number	: D3278041
This Issue	: 01/05/2008 S.O. No. :	Drawing Number	: D3278 REV.C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 01/05/2008 Type : SMALL /MED FAB	Drawing Revision	: C
Previous Run	: 37780	Material	:
Written By	:	Due Date	: 20/05/2008
Checked & Approved By	: <u>JLD 08.5.01</u>	Qty:	40 52 Um: Each
Comment	: Est:A 04.04.19 New issue KJ/JLM EST B 07.08.21 Chg rivet per PAR185 EC Verified by: JLM		

Additional Product

Job Number:




Seq. #:	Machine Or Operation:	Description :
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1.0	D32781	Support
-----	--------	---------




Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~40.0000~~ Each(s)
 Support

✓ 
 B 35593 x 10
 B 36811 x 42 > 52 ml

2.0	D32782	Support
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Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~40.0000~~ Each(s)
 Support

✓ 
 B 36119 B x 11
 B 36811 B x 41 > 52 ml

3.0	D32783	Spacer
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Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~40.0000~~ Each(s)

Spacer

Pick:

Qty	Part Number	Description	Batch
1	D3278-3	Spacer	

B 34956 x 18
 B 38935 x 34 ml

4.0	MS20426AD36	Rivet
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Comment: Qty.: 4.0000 Each(s)/Unit Total : ~~160.0000~~ Each(s) 208

RIVET

Pick:

Qty	Part Number	Description	Batch
4	MS20426AD3-6	Rivet	M105055

✓
 08/05/05 ml

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 01/05/2008 10:03:54 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ASSEMBLY

Job Number: 38929

Part Number: D3278041

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



x52

Comment: SMALL & MEDIUM FAB RESOURCE 1
Rivet spacers with support as per Dwg D3278.

ml 08/05/05

6.0 QC5 INSPECT WORK TO CURRENT STEP



counte

Comment: INSPECT WORK TO CURRENT STEP

5 08/05/05 (182)

7.0 D22301 Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: ~~80.0000~~ Each(s) 104

Mounting Lug

Pick: Packing Kit

Qty Part Number

2 D2230-1

Description

Mounting Lug

Batch

9 x B 38740 ✓
80 x B 37745 ✓
15 x B 36747 ✓

ml

8.0 AN413A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: ~~80.0000~~ Each(s) 104

Bolt

Pick: Packing Kit

Qty Part Number

2 AN4-13A

Description

Bolt

Batch

M107321 ✓

ml

9.0 AN960JD416 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: ~~160.0000~~ Each(s) 208

Washer

Pick: Packing Kit

Qty Part Number

4 AN960JD416

Description

Washer

Batch

M107321 ✓

ml

10.0 MS21042L4 Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: ~~80.0000~~ Each(s) 104

Nut

Pick: Packing Kit

Qty Part Number

2 MS21042L4

Description

Nut

Batch

M106051 ✓

ml
08/05/05

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 01/05/2008 10:03:54 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ASSEMBLY

Job Number: 38929

Part Number: D3278041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble support as per Dwg D3278.
DO NOT TIGHTEN BOLTS
Identify as D3278-041

ml 08/05/09 **X52**

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

counts
08/05/09 **(X52)**

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: *ST471*

PC 8/5/20 **(52)**

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/2009

Job Completion



mf 08-05-20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

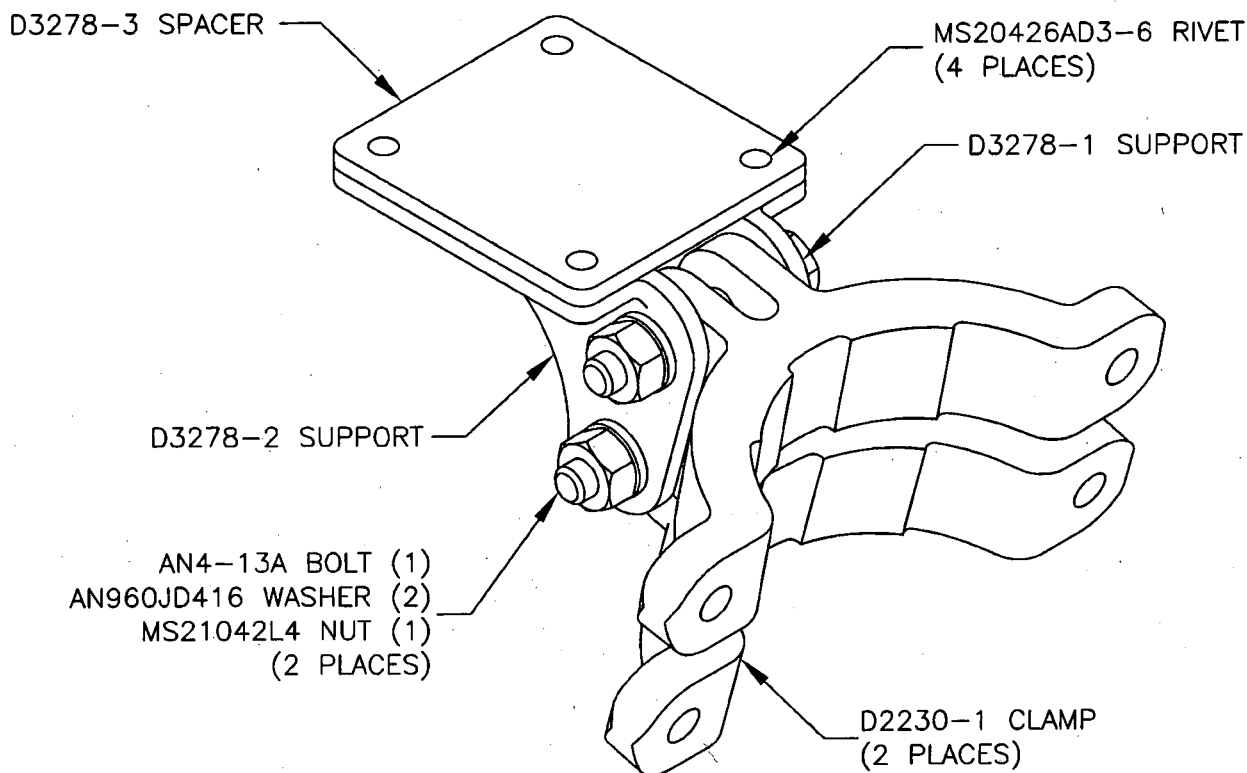
NOTE: Date & initial all entries



DESIGN <i>GP</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>JB</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

RELEASED
07 08 08

D3278-041 SUPPORT ASSEMBLY

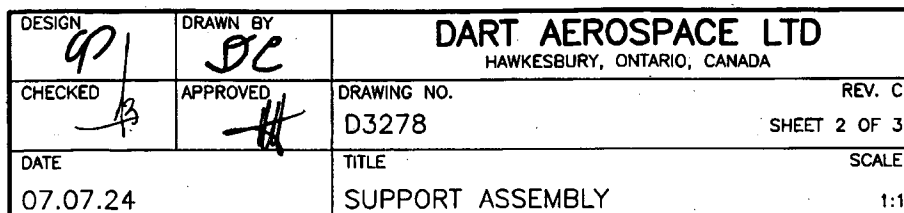


Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

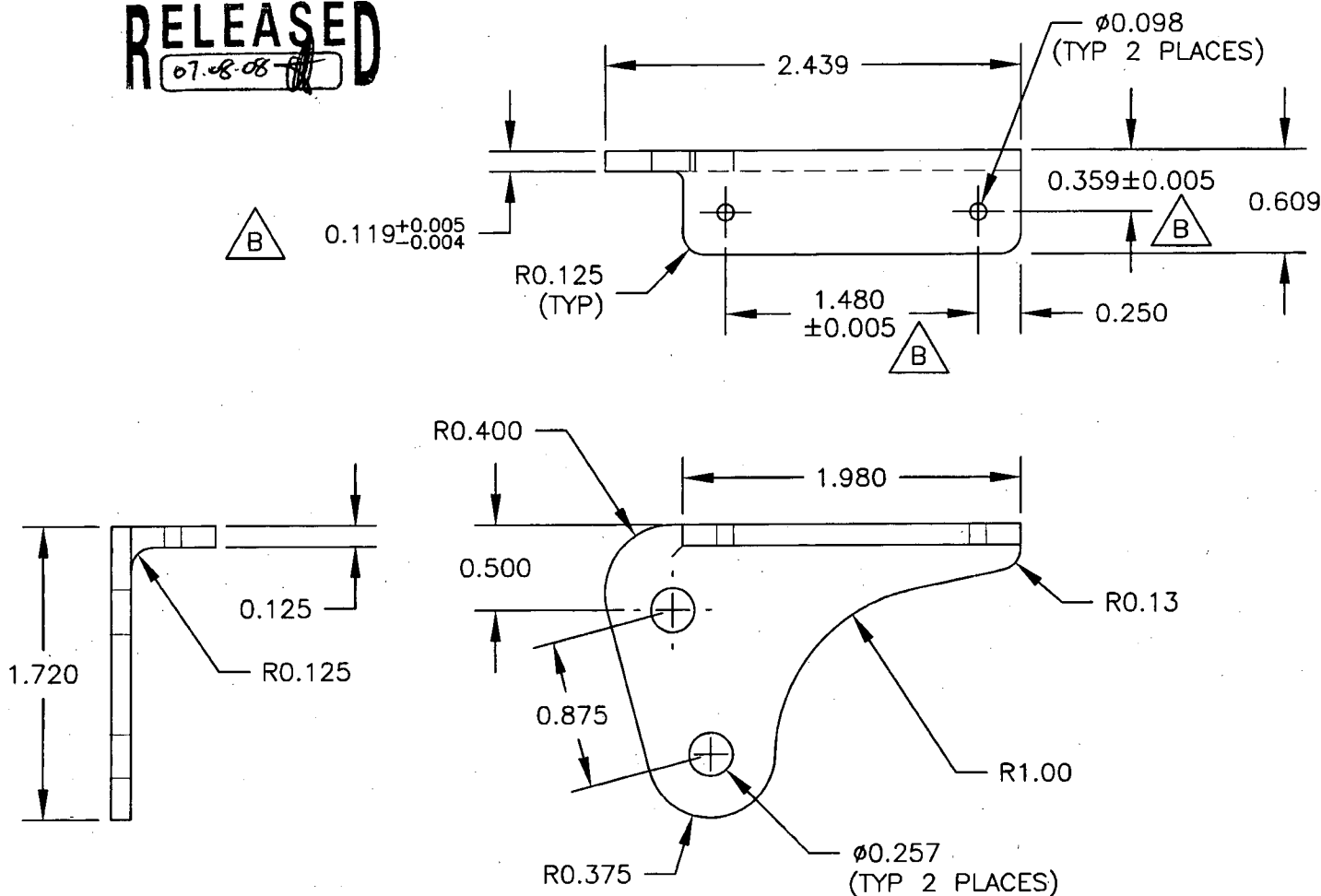
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RELEASED
07-08-08



D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

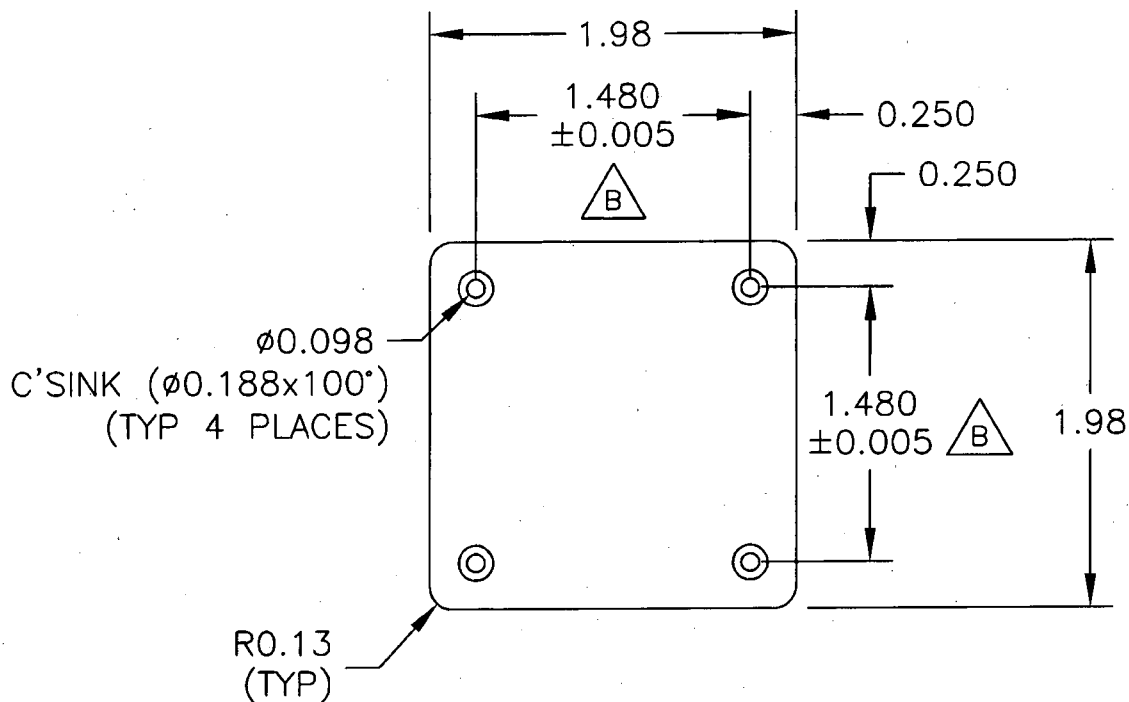
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DESIGN <i>qp</i>	DRAWN BY <i>DC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08**D3278-3 SPACER**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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